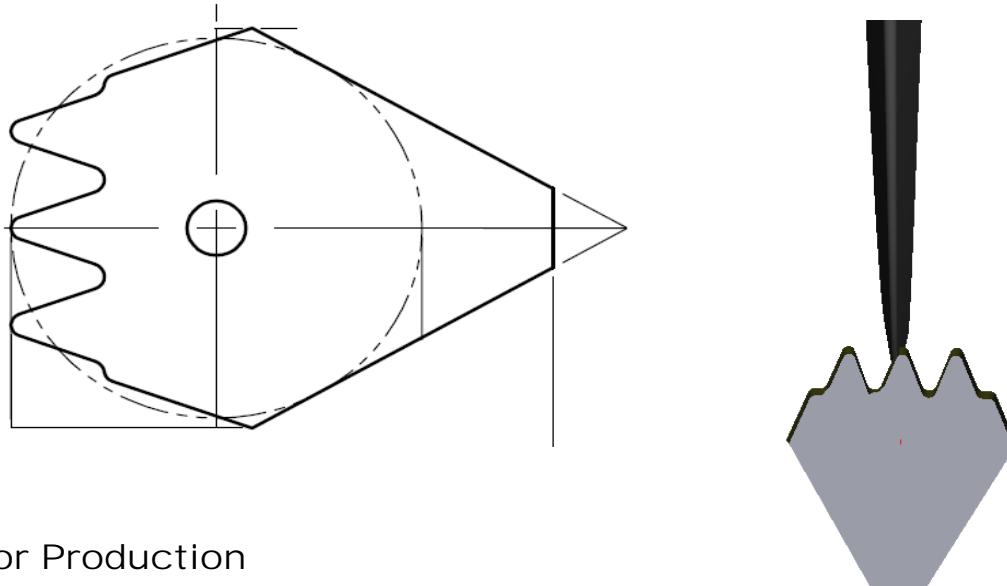


## Insert DF356-3SR ID-Ø14.0

A08-010



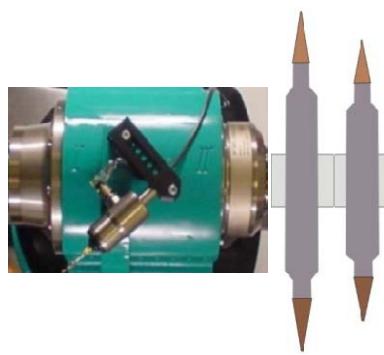
### 1. Cycletime for Production

Workpiece:	60° Ref ID-Ø14.0, T4.76 Material CARBIDE		
Operations			
Feed [mm/Min]	15	20	20
Power [kW]	4	3	2
Cutting speed [m/s]	20	20	22
Used wheels			
Grinding time [s]	62	98	96
Total cycle time	12		
4 Min 28			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14EE1 Ø200 D76V20°
2	14EE1 Ø250 D46V20°



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### 3. Machine and Software Requirements

Machines:	5 axes CNC grinders : SIRIUS HPM	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 310i	Software:	Quinto 5
Accessories:	Loader STL6050, RPC clamping		

Responsible engineer: OP, 21.5.15

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